

Work Order ID 68571

Monday, April 18, 2011 11:33:01 AM



Page 1

Item ID: D3204-1

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 4/18/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11-04-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100



Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn tube as per Folio FA356 and Dwg D3204-2-Deburr

10

6

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

11/5/17

10

6

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

11-5-17

10

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Run Start



QC:

Date:

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Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *BK*

0.00

PL 11-05-17

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

140



QC21- Final Inspection - Work Order Release

0.00

11/15/18

QC

Memo

0.00

Quality Control

MF
11-05-17

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NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 11:33:07 AM

Page 1

Work Order ID: 68571



Parent Item: D3204-1



Parent Item Name: Tube

Start Date: 4/18/2011

Required Date: 4/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B04.06.09Change Step 6; remove Steps 7 & 8KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.125 6061-T6 RD Tube .750 x .125W		Purchased	No			100	f	8.1600	0.52	5.473684		11/15/11	

Location
MAT015
111409

Loc Qty
8.16
8.16

Loc Code

5-2 PT

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DART AEROSPACE LTD	Work Order:	68574
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/3/17	Date: 11.5.17		Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

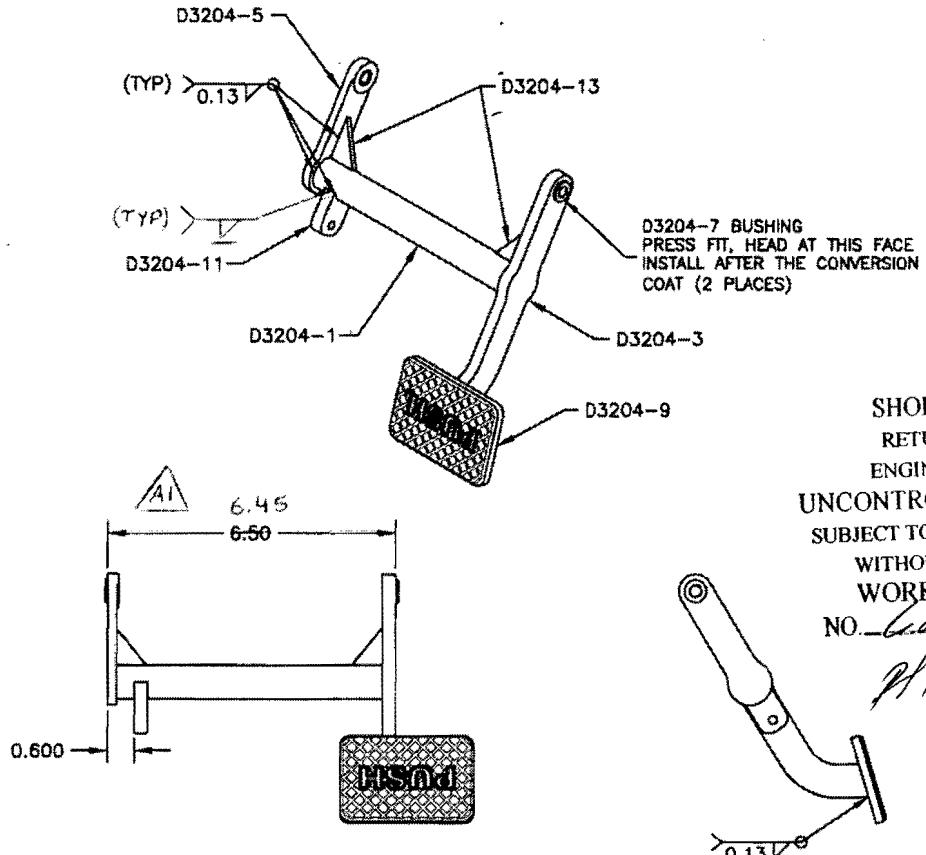
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.01.27



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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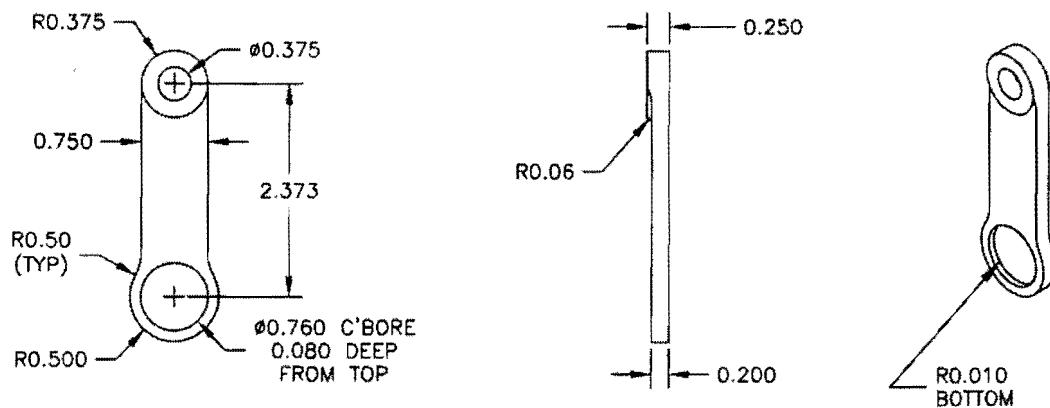
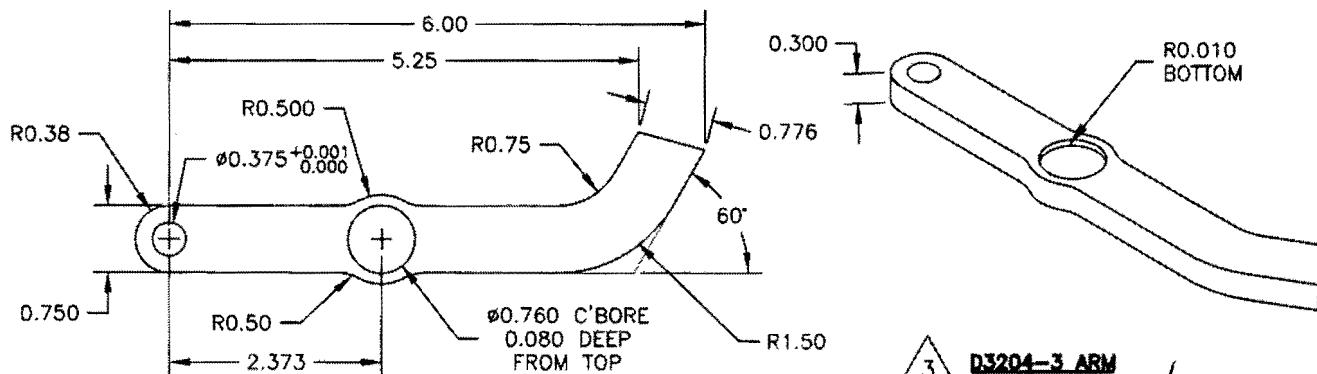
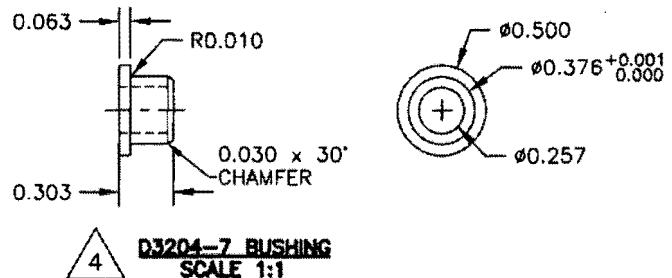
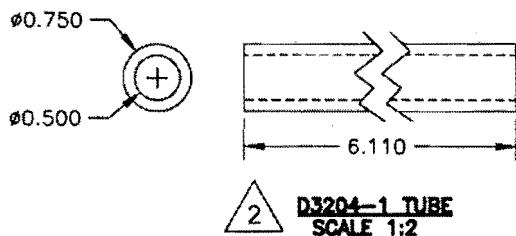
NOTE: Date & initial all entries



1 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3204 REV. A
DATE		SHEET 2 OF 3
04.01.27		TITLE RELEASE PEDAL ASSEMBLY
		SCALE NTS

RELEASED
04.04.05



W/O:		WORK ORDER CHANGES					
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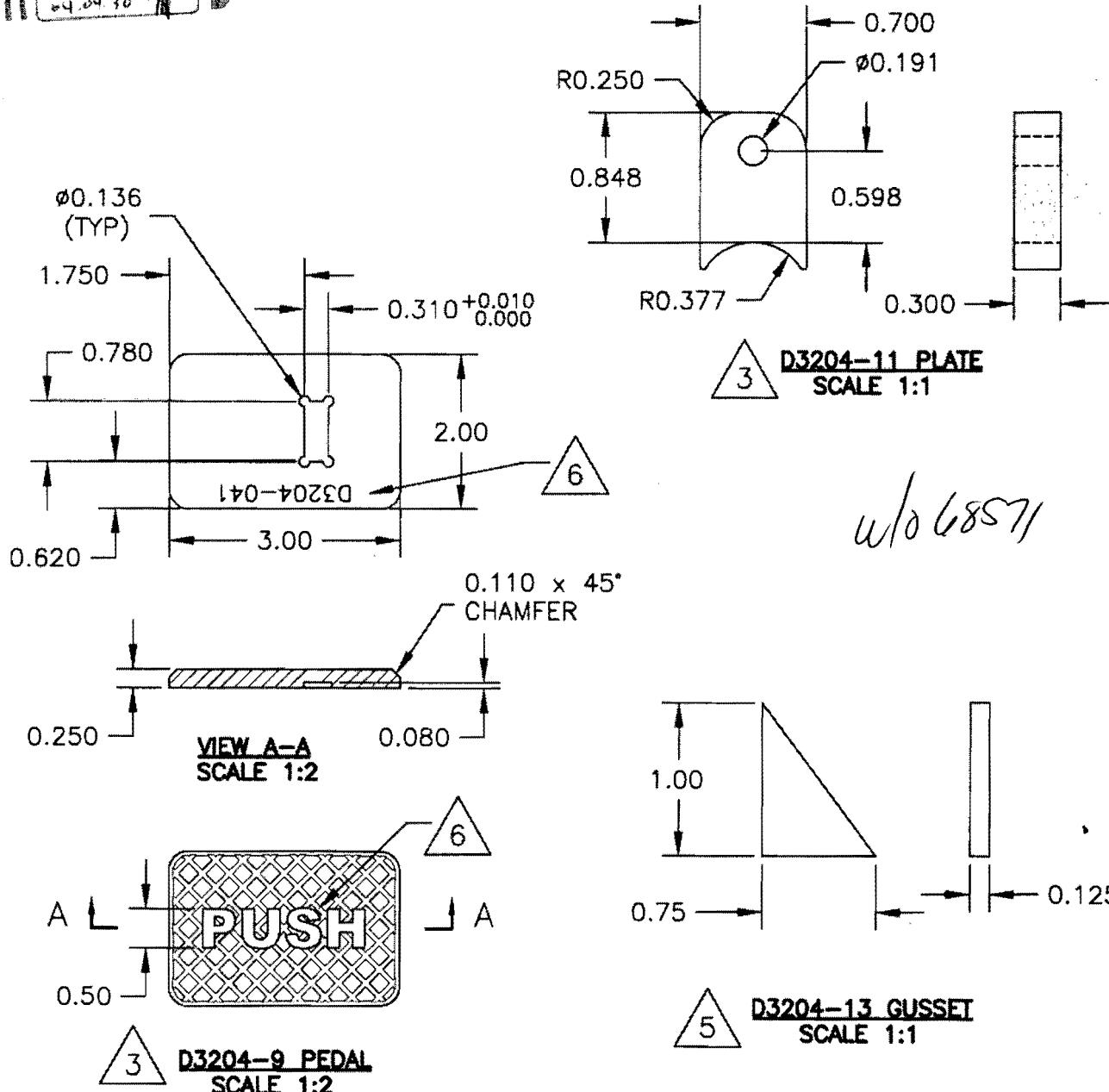
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DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.30

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